

Work Order ID 57093

Monday, March 22, 2010 8:25:48 AM



Page 1

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Upper Basket Lug Assembly, Aft					
Start Date:	3/22/2010	Start Qty:	1.00	Cust Item ID:		
Required Date:	3/31/2010	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-3-23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	PA1								

100	Weld per dwg A/R S.S. rod Batch: <u>4113328</u>	0.00							
	Large Fab								<u>10/04/26</u>
Large Fab	Memo	0.00							
Large Fab	1- assemble ribs , weld as per dwg D3914								
	2- weld hinge (3) and Mounting brackets as per dwg D3914								
	inspect before welding mesh								
	3- tack weld mesh on basket as per dwg D3914								
110	QC9- Inspect visual per QSI004- Fusion Welds ✓	0.00							
	QC								<u>10-04-29</u>
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Required Date:	3/31/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

7m-1/2 10/04/29 (12)

B57565

SB 10/04/30

10/04/30
MF
10-4-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, March 22, 2010 8:25:47 AM

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Work Order ID: 57093

Parent Item: D3914-041

Parent Item Name: Upper Basket Lug Assembly, Aft

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 3/22/2010

Required Date: 3/31/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2581		Manufactured	No			100	Each	35.0000	2.0000			
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✓ 
Mounting Bracket

SH 10/04/22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

35

46086

2

48428

1

50872

1

51120

2

51745

2

55918

27

B57185 2x

✓ D3914-1		Manufactured	No			100	Each	0.0000	2.0000			
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Rib

✓ D3914-7		Manufactured	No			100	Each	0.0000	2.0000			
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Rib

✓ D4016-3		Manufactured	No			100	Each	0.0000	3.0000			
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Hinge Half, Lid

✓ D4018-5		Manufactured	No			100	Each	0.0000	9.0000			
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Rib

✓ D4020-5		Manufactured	No			100	Each	0.0000	1.0000			
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Mesh (350 Basket Long, Lid)

B57095 ② *SH 10/04/22*

B57096 ② *SH 10/04/22*

B56950 ③ *SH 10/04/22*

B57097 ⑨ *SH 10/04/22*

B56989 ① *SH 10/04/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 22, 2010 8:25:47 AM

Work Order ID: 57093



Parent Item: D3914-041



Parent Item Name: Upper Basket Lug Assembly, Aft

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

✓ D4021-3		Manufactured	No			100	Each	1.0000	1.0000			
Data Plate												

B57109 ① *SY* 10/04/22

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	1	
56050	1	

✓ D4035-041		Manufactured	No			100	Each	0.0000	1.0000			
Lid Rib Assembly, Fwd (350 Basket)												

B56984 ① *SY* 10/04/22

✓ D4035-043		Manufactured	No			100	Each	0.0000	1.0000			
Lid Rib Assembly, Aft (350 Basket)												

B57604 ① *SY* 10/04/22

D2728-3		Manufactured	No			140	Each	0.0000	1.0000			
Lid Rib Assembly, Aft (350 Basket)												

ES 10/04/20 ①

Dart Logo label												
D4086-210 <i>S</i>		Manufactured	No			140	Each	0.0000	1.0000			
Placard, Max Load												

B56978

ES 10/04/20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

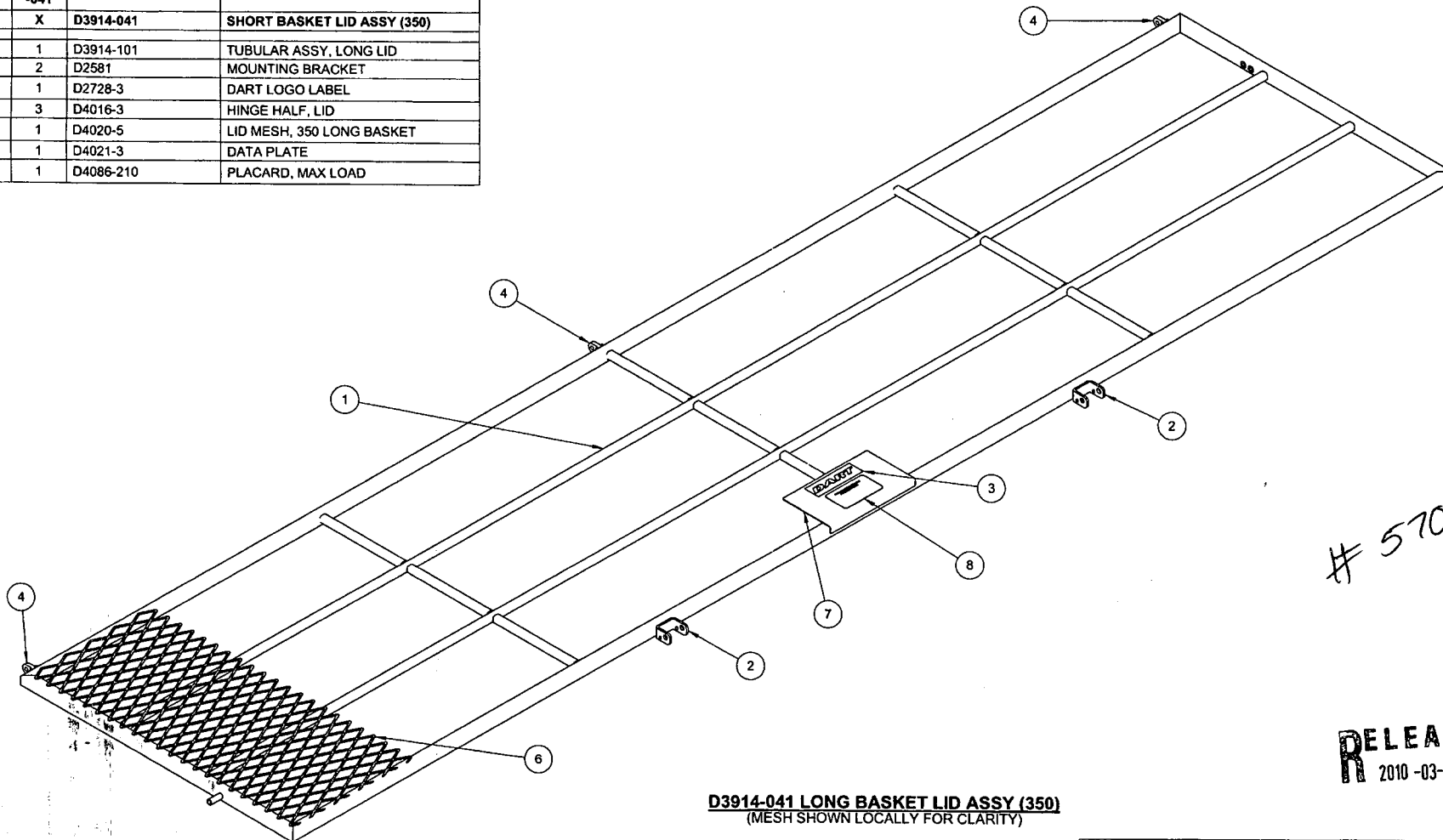
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

57093

RELEASED
2010-03-22

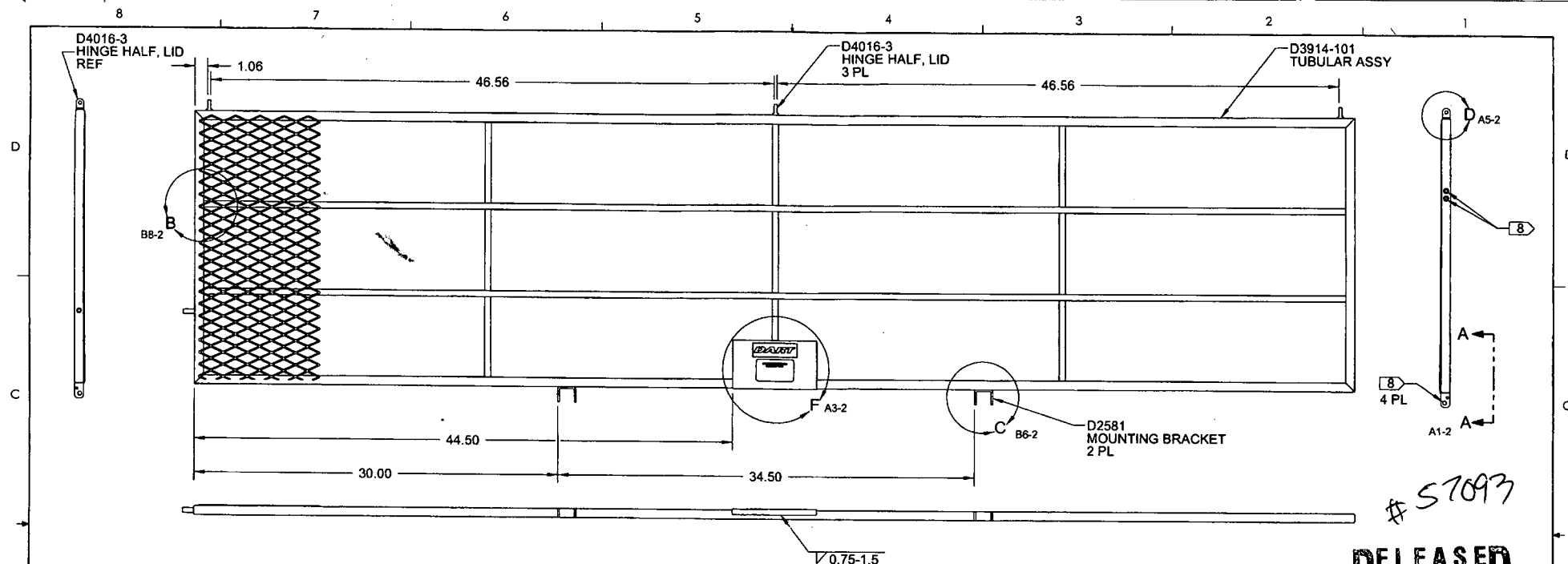
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DESIGN	AJS	BY	DATE
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

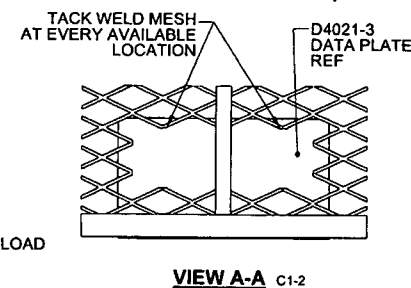
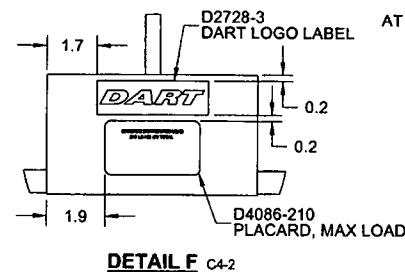
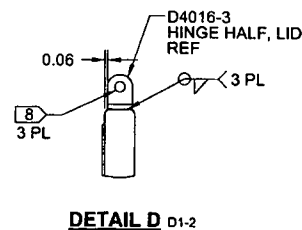
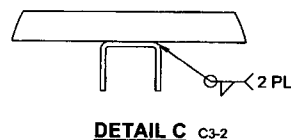
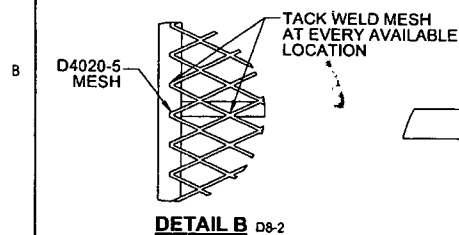
DRAWING NO. **D3914** REV. A
SHEET 1 OF 4

TITLE **LONG BASKET LID ASSY (350)** SCALE NTS





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D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



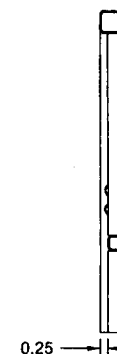
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.35 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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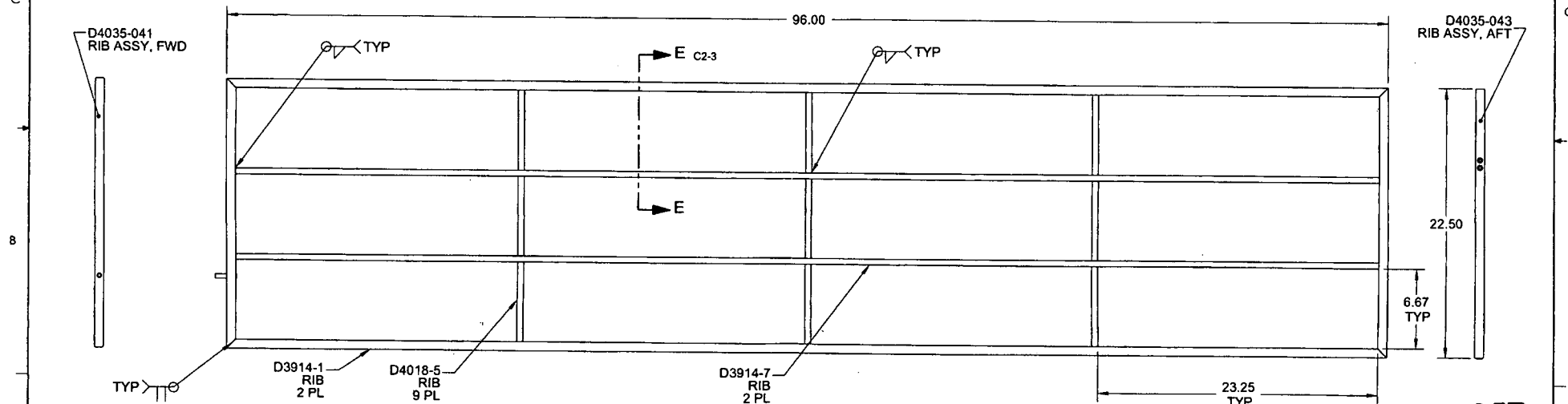
RELEASED
2010-03-22

#57093

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



NOTES:

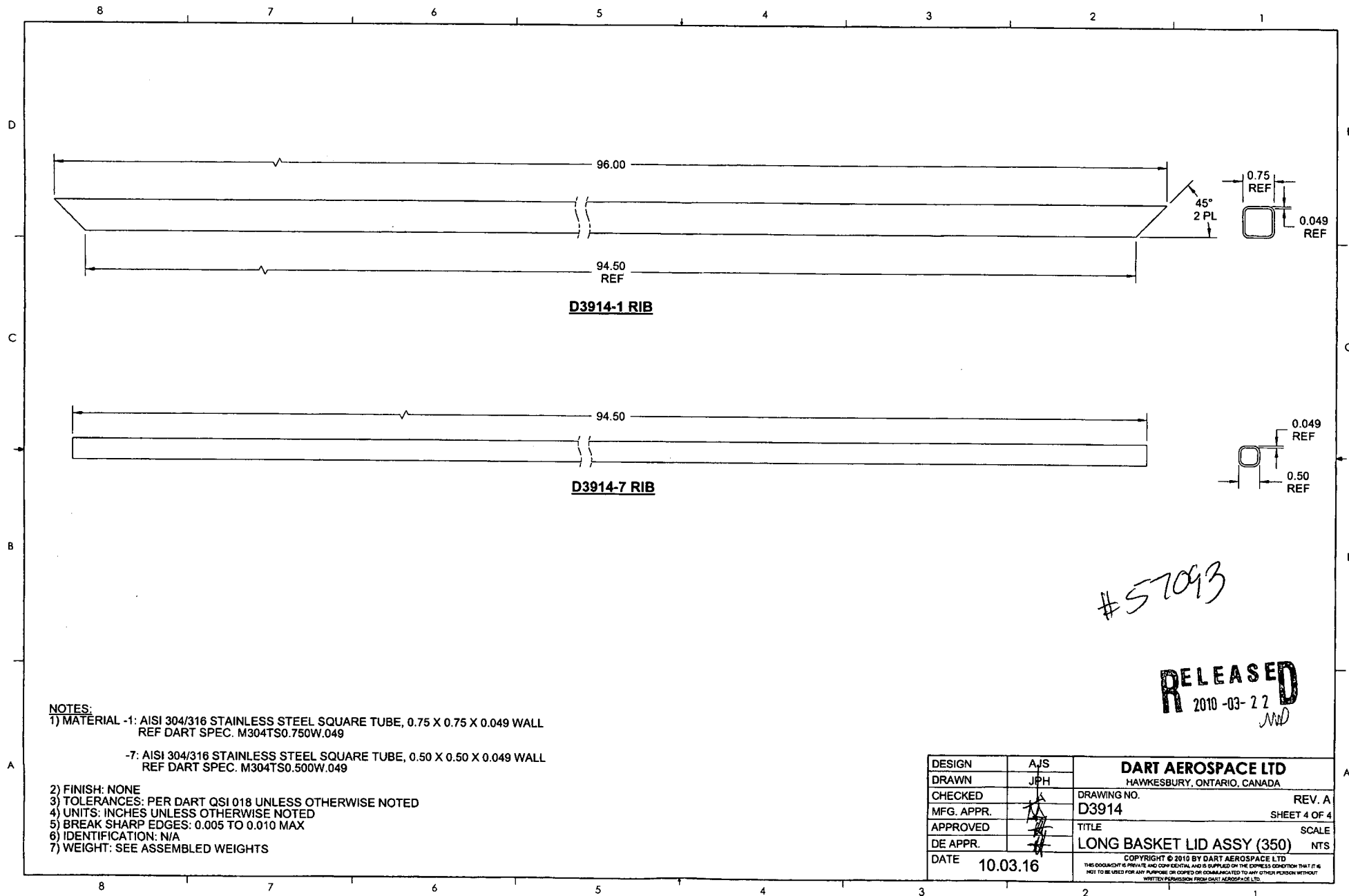
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

8 D3914-101 TUBULAR ASSY, LONG LID

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3914	REV. A
MFG. APPR.		TITLE LONG BASKET LID ASSY (350)	SCALE NTS
DE APPR.		COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.03.16		

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2010-03-22
AJP

#57093



NOTES:

1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

#57093

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2010-03-22
JND

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.	A	D3914	SHEET 4 OF 4
APPROVED	A	TITLE	SCALE
DE APPR.	A	LONG BASKET LID ASSY (350)	NTS
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